

Work Order ID 60083

June 24, 2010 9:10:59 AM



Page 2

Item ID: D3259-3

Accept



Work Order ID 60083

June 24, 2010 9:10:58 AM



Page 1

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024.063	1-Cut as per Dwg D3259 11Dwg Rev: <i>B</i> 11Prog Rev: <i>B</i> 112-								
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

B 10-6-24

(4)

B 10-6-24

(4)

8/6/06/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 60083



Page 3

June 24, 2010 9:10:59 AM

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		BL 10-6-30.	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	Ø		
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>180A</u> Memo	0.00 0.00							PC 10/7/01 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60083

Page 4

June 24, 2010 9:11:00 AM

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01

MP

10-07-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:10:58 AM

Page 1

Work Order ID: 60083

Parent Item: D3259-3

Parent Item Name: Doubler



Start Date: 6/24/10

Start Qty: 4.00

Required Date: 7/02/10

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

122.7000

1.388

5.844211



2024-T3 .063 sheet



1310-6-24

Location

Loc Qty

Loc Code

MAT22

122.7

113866

18.5

114351

104.2

114351

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>100283</i>	
Description: Doubler		Part Number: D3259-3/-4	
Inspection Dwg: D3259 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.062	+/-0.010					
9.000	+/-0.005	8.997	✓			
1.000	+/-0.005	1.998	✗			
0.260	+/-0.010	.261	✓			
0.900	+/-0.010					
R0.25	+/-0.030	.25	*			
R0.50	+/-0.030	.50	✓			
5.000	+/-0.005	5.000	✗			
0.875	+/-0.005	.874	*			
1.300	+/-0.010					
12.000	+/-0.005	12.001	✗			
3.500	+/-0.005	3.500	✓			
0.875	+/-0.005	.872	✓			
R0.13	+/-0.030	.13				
0.500	+/-0.005	.500	✓			
0.525	+/-0.005	.528	✗			
1.80	+/-0.030	1.799	✗			
Ø0.128	+0.005/-0.000	.131	✗			
Ø0.377	+0.005/-0.000	.380	✗			
Ø0.098	+0.005/-0.000	.102	✗			
0.063 thick	+/-0.005	.064	✗			
Grain Direction	N/A		✓			

Measured by: <i>IB</i>	Audited by: <i>S</i>	Preliminary Approval:
Date: 10-6-24	Date: 10/6/25	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	<i>[Signature]</i>

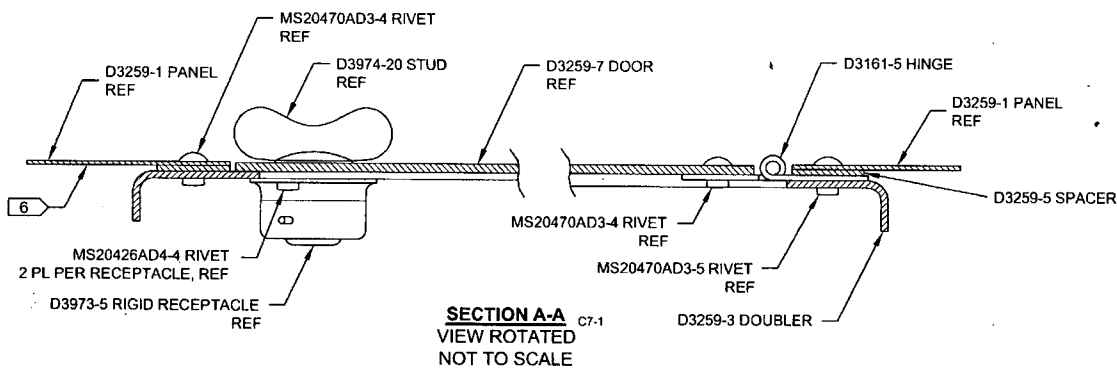
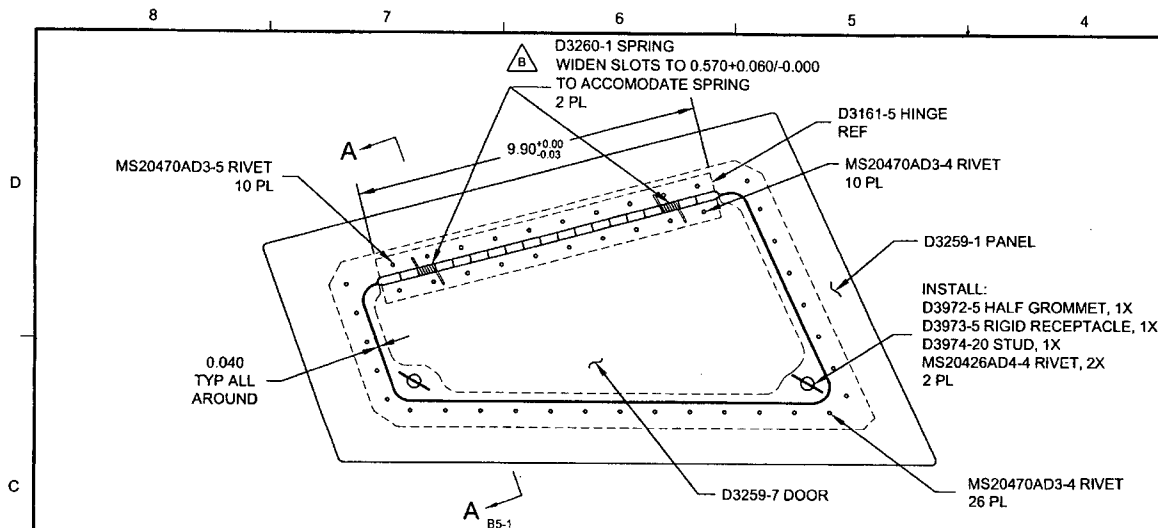
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-041 ACCESS PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET

B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5)	CP	09.08.12
A	NEW ISSUE	CP	04.02.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.12		

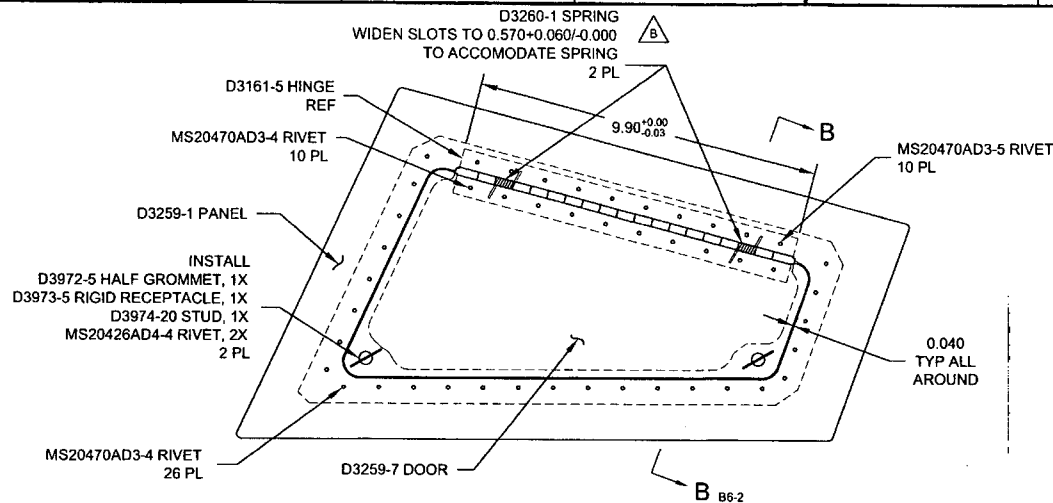
RELEASED
2009-10-08
WIP

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

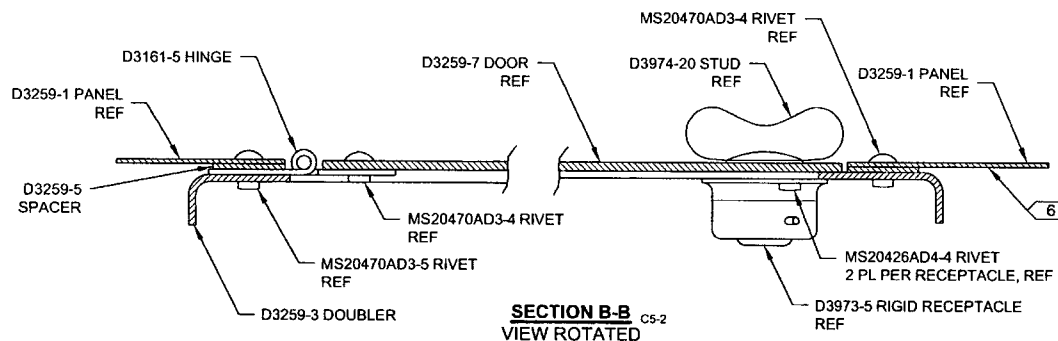
DRAWING NO. D3259
REV. B
SHEET 1 OF 8
TITLE ACCESS PANEL ASSEMBLY
SCALE NTS

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8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-042 ACCESS PANEL ASSEMBLY

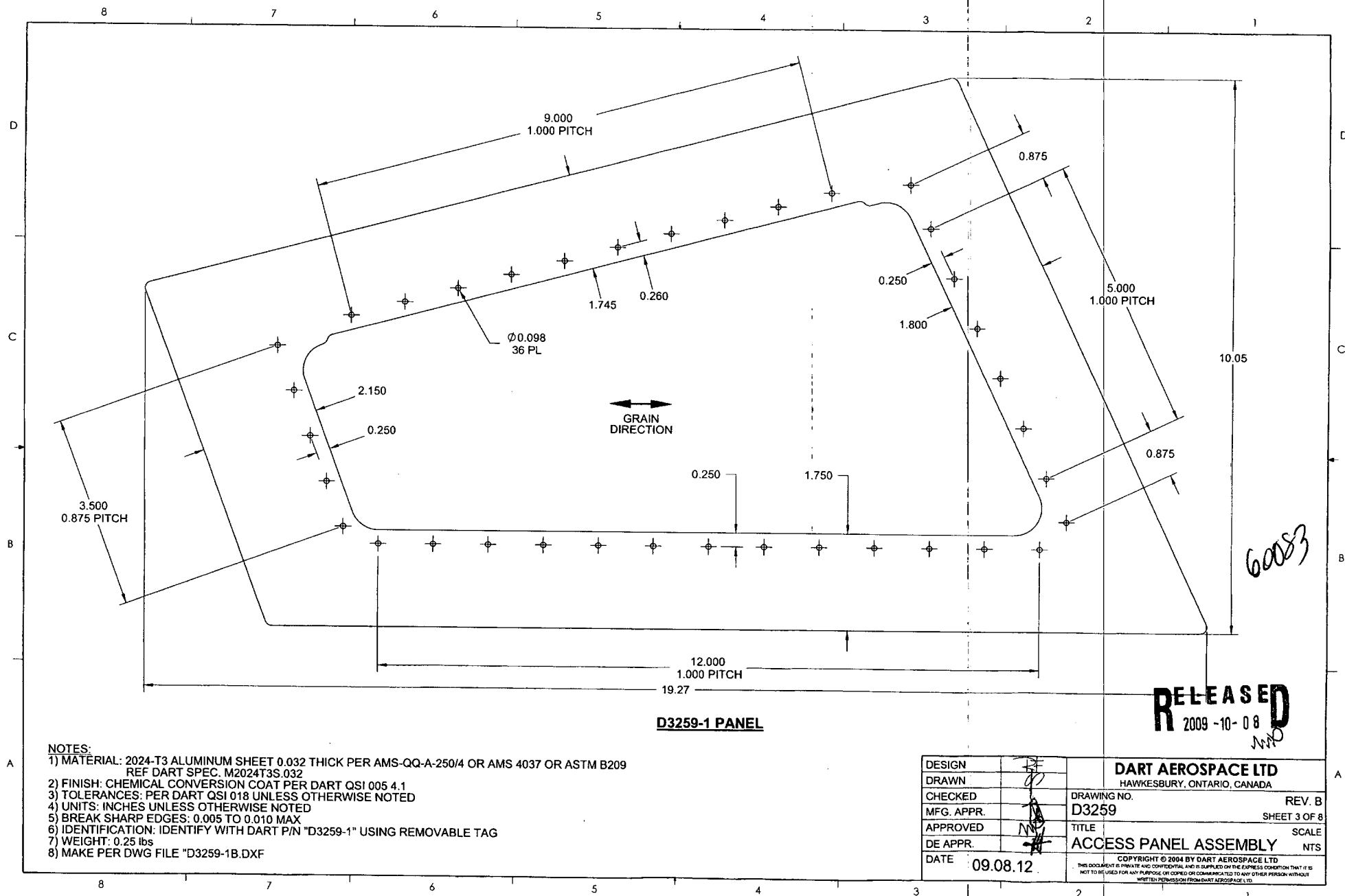
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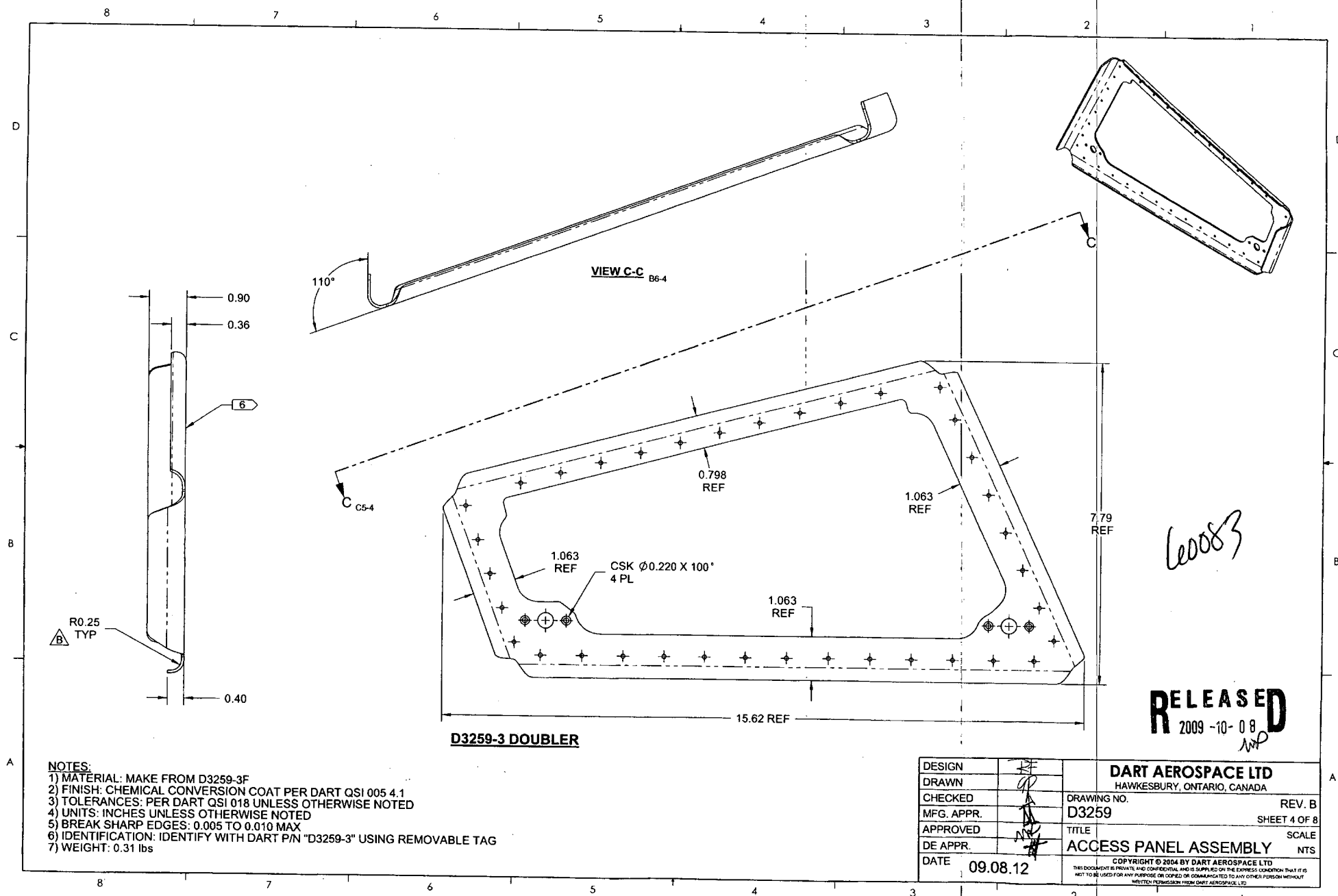
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

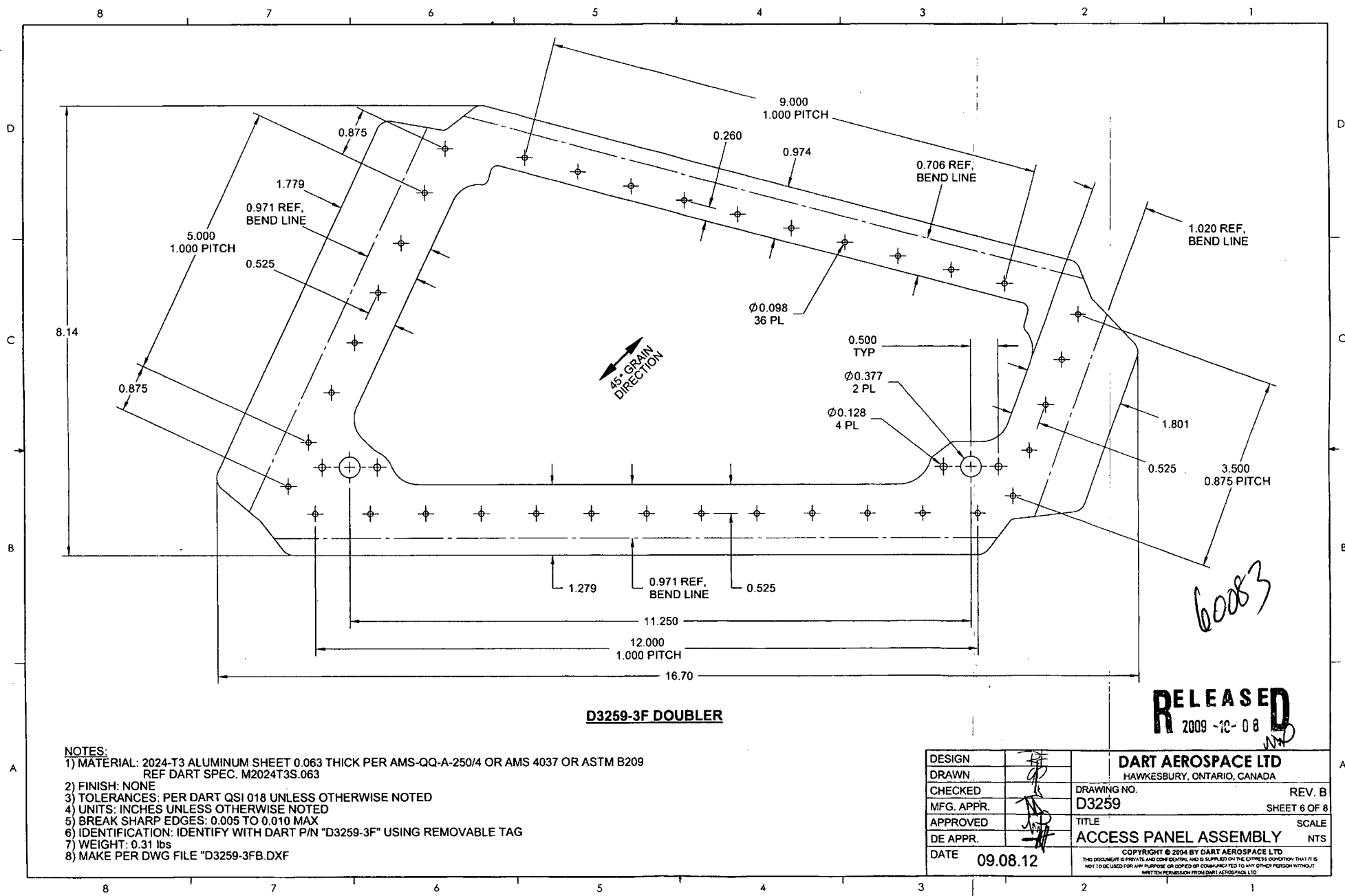
RELEASED
2009-10-08

DESIGN	RF	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3259 SHEET 2 OF 8
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL ASSEMBLY NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD

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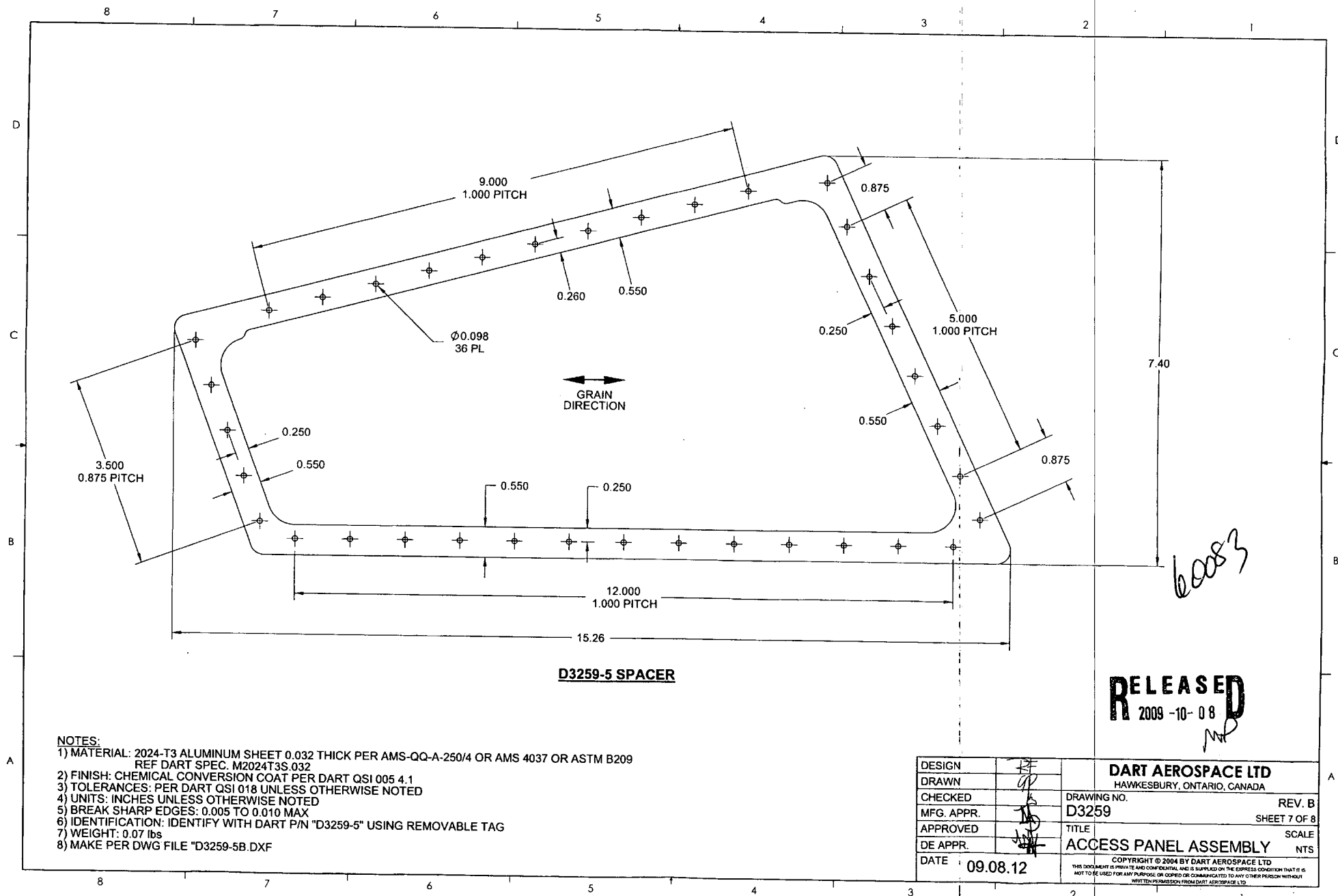


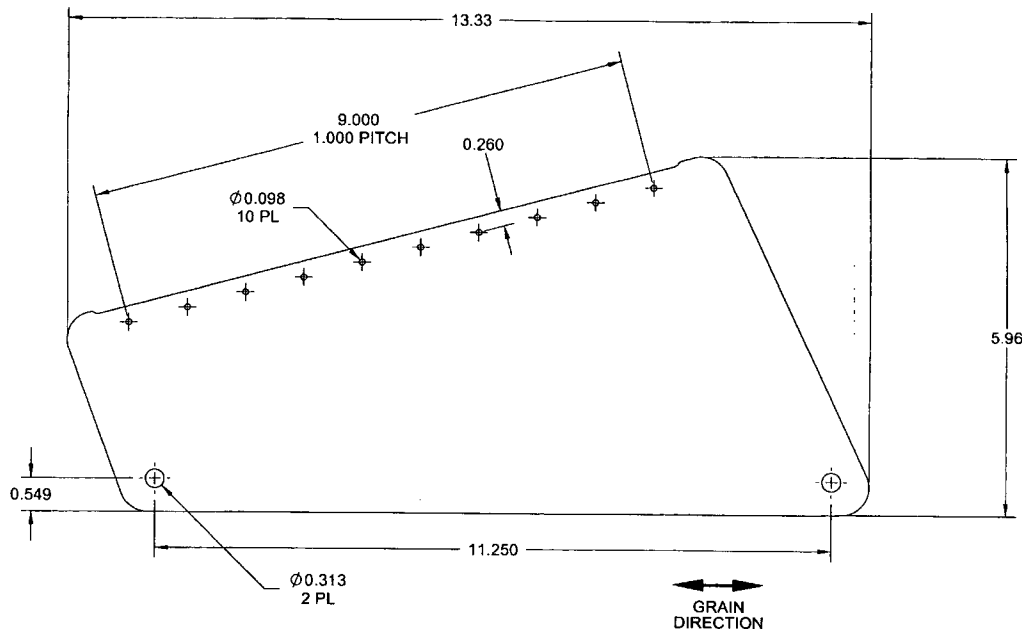
D3259-3F DOUBLER

RELEASED
2009-10-08

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
 - 7) WEIGHT: 0.31 lbs
 - 8) MAKE PER DWG FILE "D3259-3FB.DXF"

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3259 TITLE ACCESS PANEL ASSEMBLY SCALE NTS <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		REV. B SHEET 6 OF 8
DATE	09.08.12	





D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
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